Work Order ID 68470

Page 1

Wednesday, April 13, 2011 4:16:11 PM

Item	ID.
ICCIII	11.

D3455-3

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 4/20/2011

Spacer

Start Oty: 20.00 4/13/2011

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Rea'd Otv: 20.00

Date: //-04/3 Tooling:

Date:

Start Run



Revision Nbr

Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID Operation Description Set Up/ Run Hours Tool ID

1

Tool # Plan Code

Reject Accept Qty Oty

23 \$

Reject Number Stamp

Insp.

Draw Nbr D3455

Rev A

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

0.00

0.00

1-TURN A\$ PER FOLIO FA584 & DWG D3455, □FOLIO

REV: N/ J □DWG REV:

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

120

Quality Control

QC8- Inspect parts - second check

0.00

PA 11.5.25 23

Memo

0.00

Dart Aerospace Ltd

W/O:				W	ORK ORDER CHANG	ES					<u> </u>
DATE	STEP	PRO	CEDURE	СН	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										•	
							,				
Part No	•	PAR #:	Faul	Cate	egory:	_ NCF	: Yes 1	lo DQ	A :	_ Date: _	
	R	esolution:								Date:	
NCR:		V	VORK (ORE	DER NON-CONFORMA	ANCE	(NCR))			
DATE	STEP	Description of NC Section A	Initia		Corrective Action Section Action Description	on B	Sign &	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
			Chief	ng	Chief Eng		Date		•		
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NOTE: Date & initial all entries

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Work Order ID 68470

Wednesday, April 13, 2011 4:16:11 PM



Page 2

Item ID:

D3455-3

Accept



Setup Start

Stop



Revision ID:

Item Name: Spacer

Required Date: 4/20/2011

4/13/2011

Start Oty: 20.00

Req'd Oty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Start

Run

Accept

Qty



Stop

Reject

Number

Reject

Qty

Insp.

Stamp

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo Deburr if necessary Set Up/ **Run Hours**

0.00

140

QC

Quality Control

OC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: 059

Memo

0.00

150

Packaging Packaging

Memo

0.00

0.00

Dart Aero	space	Ltd
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W/O:				W	ORK ORDER CHANG	ES					£.
DATE	STEP	PRO	CEDURE	СНА	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								···-			
Part No	:	PAR #:	Fault	Cate	gory:	_ NCI	R: Yes	No DQ	A :	Date:	
	R	esolution:	i							Date: _	
NCR:		V	VORK (ORD	ER NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initia Chief E		Corrective Action Section Action Description Chief Eng	on B	Sign & Date		cation tion C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 68470

Page 3

Wednesday, April 13, 2011 4:16:11 PM

Item ID:

D3455-3

Accept

Setup Start



Stop

Stop

Revision ID:

Start Date:

Item Name:

Required Date: 4/20/2011

Spacer

4/13/2011

Start Oty: 20.00

Reg'd Oty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

OC21- Final Inspection - Work Order Release

Date:

Tooling:

Date:

Start Run



OC:

Operation

Description

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Accept Reject

Reject

Insp.

Sequence ID/ Work Center ID

160

Ouality Control

Memo

0.00

0.00

Qty Qty Code

Number Stamp

11/5/26 MC 11-05-26

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC Inspector Approval Chief Eng / Prod Mgr QC Inspector

Part No:		PAR #:	Fault	Category:	NCR: Yes 1	lo DQA:	Date:	<u></u>
	Resolution:		Disp	osition:	QA: N/C Clo	sed:	Date:	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E	}	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng			Section C	Chief Eng	QC Inspector
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								3
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	1							

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 4:16:17 PM

Work Order ID: 68470

Parent Item:

D3455-3

Parent Item Name:

Spacer



Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 20.00

Required Oty: 20.00

Comments:

IPP REV. A 05.11.17

NEW ISSUE

EC

Component Item ID/	
Item Name	

Replacement Mfg/ Item ID

Purch

Bin Item

Primary Last Location Location

Route Seq ID Unit of Measure

Qty on Hand

Qty per Kit Total

Oty

Qty Issued

Date Issued

Status

MDELRINR1.000

Purchased

No

100

f

4.7680

0.022

0.463158

Delrin Round Bar 1

One Line only

Location

MAT055

Loc Oty 4.768 4.768

Loc Code

104930

Page 1

Dart Aero	space	Ltd
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W/O:				W	ORK ORDER CHANGE	ES					ſ
DATE	STEP	PRO	CEDURE	СНА	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									:		
Part No	:	PAR #:	Fault	Cate	egory:	NCF	R: Yes	No DQ	A:	Date: _	
	R	esolution:	Disp	sitic	on:	QA:	N/C Clo	sed:		Date: _	
NCR:		V	VORK (RD	ER NON-CONFORMA	NCE	(NCR)			
DATE	STEP	Description of NC	1-141	. 1	Corrective Action Section	on B	Sign &		cation	Approval	Approval
	J	Section A	Initia Chief Er	ng	Action Description Chief Eng	٠	Date	Sect	ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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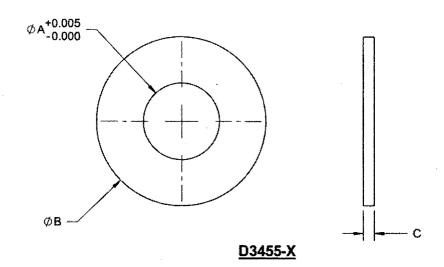
DART AEROSPACE LTD	Work Order:	68470
Description: Spacer	Part Number:	D3455-3
Inspection Dwg: D3455 Rev: A		Page 1 of 1

	FIRS	ST ARTICLE II	NSPECTI	ON CHE	CKLIST		•
		X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
Ø0.386	+0.005/-0.000	0,387			217-0		
Ø1.00	+0.010/-0.001	\$ 1.000	//				
0.050	+/-0.010	-050	./				
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Measured by:	5	Audited by:	25		Prototype /		N/A
Date:	n/5/25	Date:	11.5	-25		Date:	N/A
Rev Date	Change					Revised by,	Approved
A 06.07.11	New Issue					KJ/JLM 🚓	1 82



DESIGN R		DRAWN BY RF	DART AERO HAWKESBURY, C	SPACE LTD DITARIO, CANADA
CHECK	ED#	APPROVED	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE	***************************************	······································	TITLE	SCALE
	05.0	09.02	SPACER	2:1
Α	0	5.09.02	NEW ISSUE	

RELEASED 05.12.09 9



1) SPECIFICATION: D3455-X SPACER



WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

CX11/05/19 W10' 68470

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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